

Date: Friday, 16/05/2008 2:31:02 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COVER
Job Number : 39331	
Estimate Number : 13273	
P.O. Number :	Part Number : D32023
This Issue : 16/05/2008 S.O. No. :	Drawing Number : D3202 REVC PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : C PRELIM
Previous Run : 38789	Material :
Written By : <i>[Signature]</i> 08-05-16	Due Date : 23/05/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev: A new issue 08-04-21 DD verified by: EC	

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S032 5052-H32 .032 Sheet

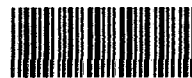


Comment: Qty.: 1.6286 sf(s)/Unit Total : 1.6286 sf(s)

5052-H32 .032 Sheet

Batch: 107513 IB 8-5-20

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3202

Dwg Rev: C

Prog Rev: C

IB 8-5-20



2-Deburr if necessary IB 8-5-20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 39331

Part Number: D32023

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

n/a

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

send to eagle Dwid

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

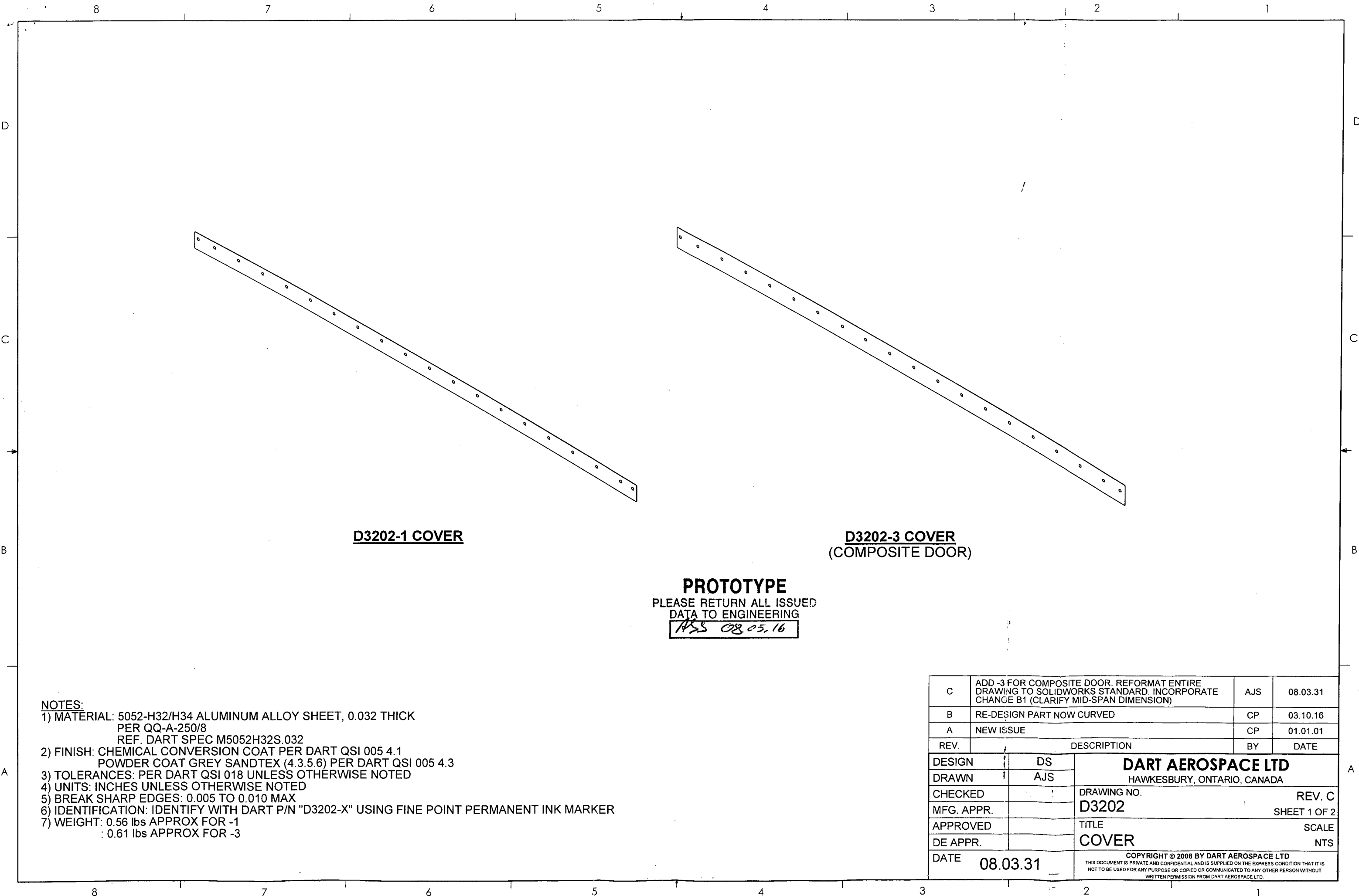
08/08/2008

Job Completion



Change To w/o 00220

to 8.05.20



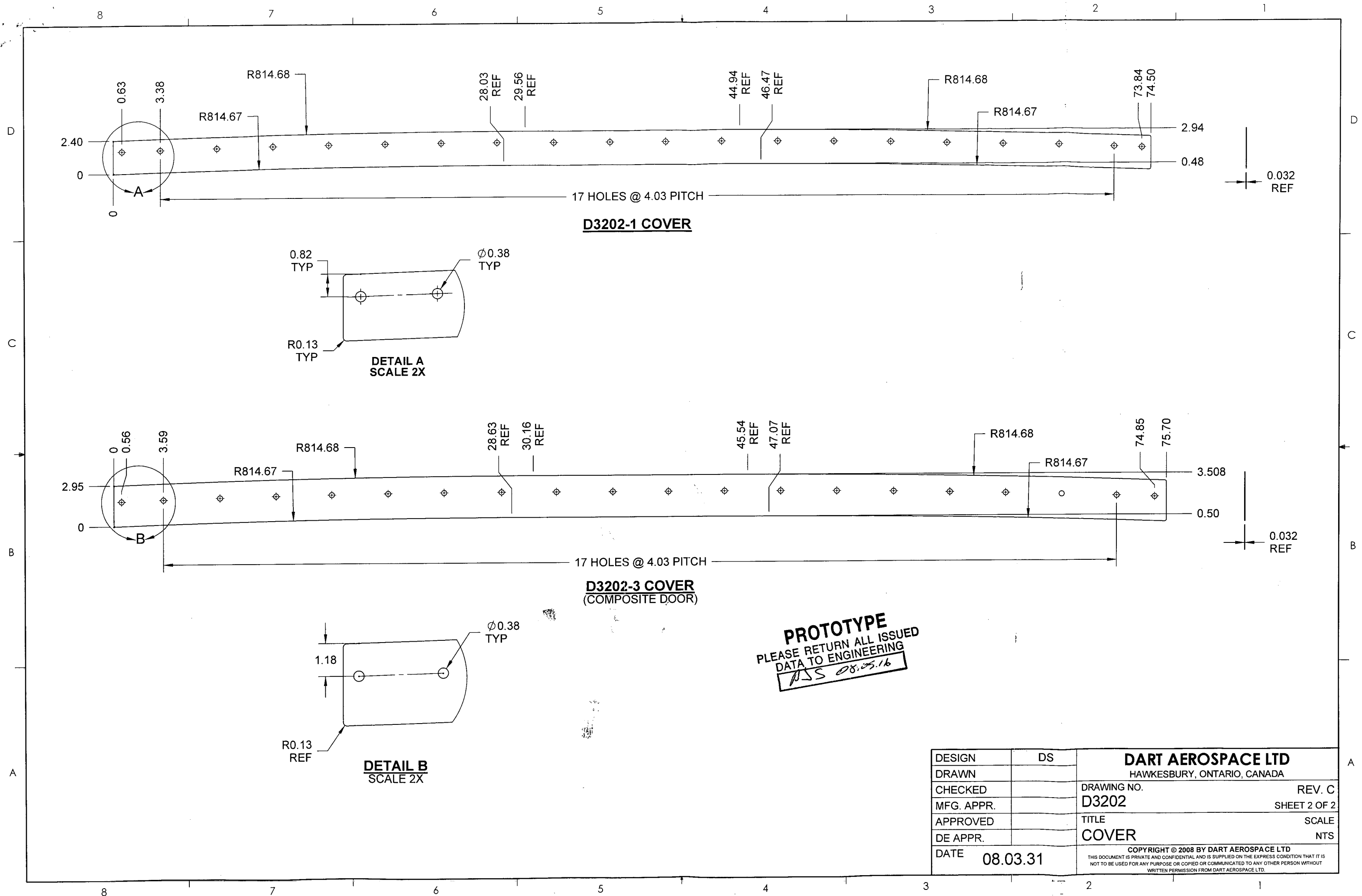
D3202-1 COVER

**D3202-3 COVER
(COMPOSITE DOOR)**

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
ASS 08.05.16

- NOTES:**
1) MATERIAL: 5052-H32/H34 ALUMINUM ALLOY SHEET, 0.032 THICK
PER QQ-A-250/8
REF. DART SPEC M5052H32S.032
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3202-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.56 lbs APPROX FOR -1
: 0.61 lbs APPROX FOR -3

C	ADD -3 FOR COMPOSITE DOOR. REFORMAT ENTIRE DRAWING TO SOLIDWORKS STANDARD. INCORPORATE CHANGE B1 (CLARIFY MID-SPAN DIMENSION)	AJS	08.03.31
B	RE-DESIGN PART NOW CURVED	CP	03.10.16
A	NEW ISSUE	CP	01.01.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3202	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
DATE	08.03.31	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-698

Job #: 00220

Date: 16-May-08

Product Name: Cabin Door Roller Kit (Comp Door)

Requested By: AJS

Design Manager Approval: 

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3202-3	COVER	16-May-08		20-May-08		

